

Work Order ID 71119

Thursday, June 23, 2011 11:04:23 AM



Page 1

Item ID:	D3180-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Strut Assembly					
Start Date:	6/23/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/7/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CY</u>	Date:	<u>11/06/23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3180	Rev B								

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Punch Tubing to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180								

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Drill Ø0.203" as per Dwg D3180 2-Bend one side only as per Dwg D3180 Identify as D3180-1 3-Deburr edges								

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

SB 11/11/07

SB 11/11/07

SB 11/11/07

4

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Date:

Stop

Date:

**Insp.
Stamp**

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

01-

0.00

Memo

0.00

Quality Control

Small Fab

Memo

Small Fab

1-Assemble as per Dwg D3180

0.00

0.00

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71119

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Item ID: D3180-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Assembly

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 5271 0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Sp 11-11-14

11/11/14
ME
mm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71119

Parent Item: D3180-041

Parent Item Name: Strut Assembly



Start Date: 6/23/2011

Required Date: 7/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 03.01.27 New issue KJ/RF
IPP Rev:B 07-06-28 Asper Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10 Screw		Purchased	No			100	Each	202.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST290		150							
					117441	150							
				ST291		52							
					115935	52							
A1449 Grommet		Purchased	No			150	Each	1,180.000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST281		1180							
					1487	1180							
AN960JD10 Washer	NAS1149D0363J	Purchased	No			150	Each	0.0000	3	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST283		3							
					113002	3							
BLRS-001 Pip Pin		Purchased	No			150	Each	3.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST283		3							
					113002	3							

LD M117601 (2C)

M115307 (4x)
M118140 (1x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71119

Parent Item: D3180-041

Parent Item Name: Strut Assembly

Start Date: 6/23/2011

Required Date: 7/7/2011

Start Qty: 4.00

Required Qty: 4.00

D2022-101 Manufactured No

150 Each

98.0000

2 8



Spacer

Location

Loc Qty

Loc Code

ST504

98

69532

38

69824

60

D2690-6 Manufactured No

150 Each

46.0000

1 4



Lanyard Assembly

Location

Loc Qty

Loc Code

ST020

46

66873

1

70920

45

M304TR0.750W.065 Purchased No

150 f

31.5000

3.5833

15.08758



304 RD Tube .750 x .065W

Location

Loc Qty

Loc Code

MAT017

31.5

114002

31.5

M117990

150 Each

2,025.000

1 4

MS21042L3 Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

2025

116549

325

117441

800

117601

400

117885

500

Handwritten notes and signatures:
 B71840
 B73324
 So 1169/13
 M119675
 (4X)

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

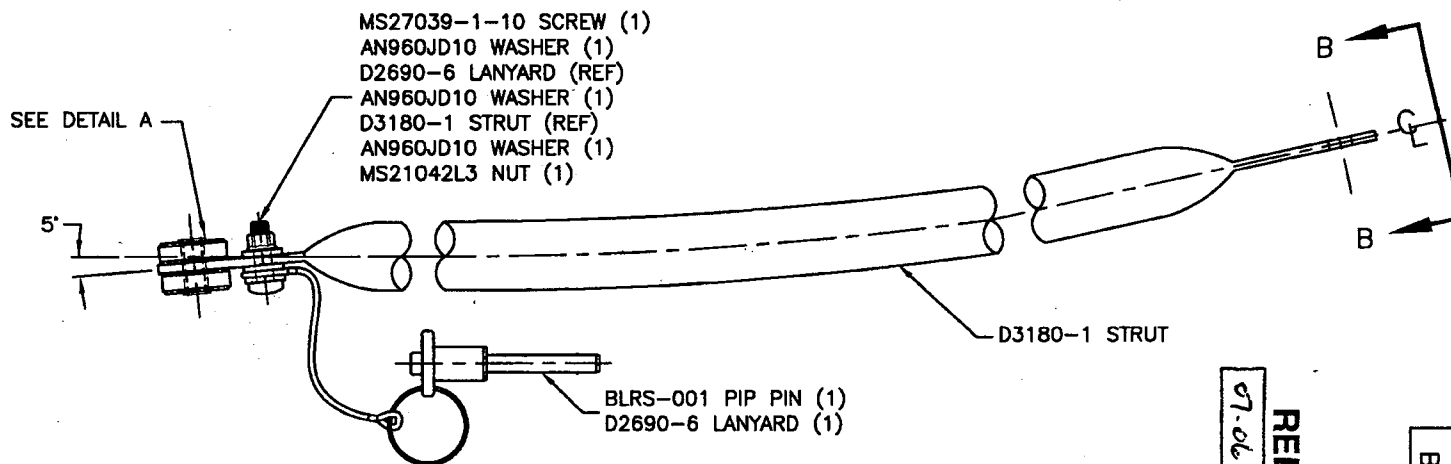
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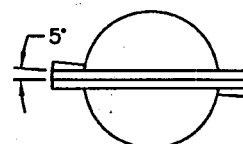
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CE</i>	DRAWING NO. D3180	REV. B	SHEET 1 OF 2
DATE 07.05.23		TITLE STRUT ASSEMBLY	SCALE 1:2	
A	03.01.06	NEW ISSUE		
B	07.05.23	CURVE ADDED		

RELEASED
07.06.08

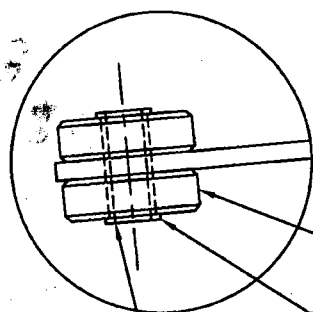


D3180-041 STRUT ASSEMBLY



VIEW B-B
SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
71119
02/10/06/23

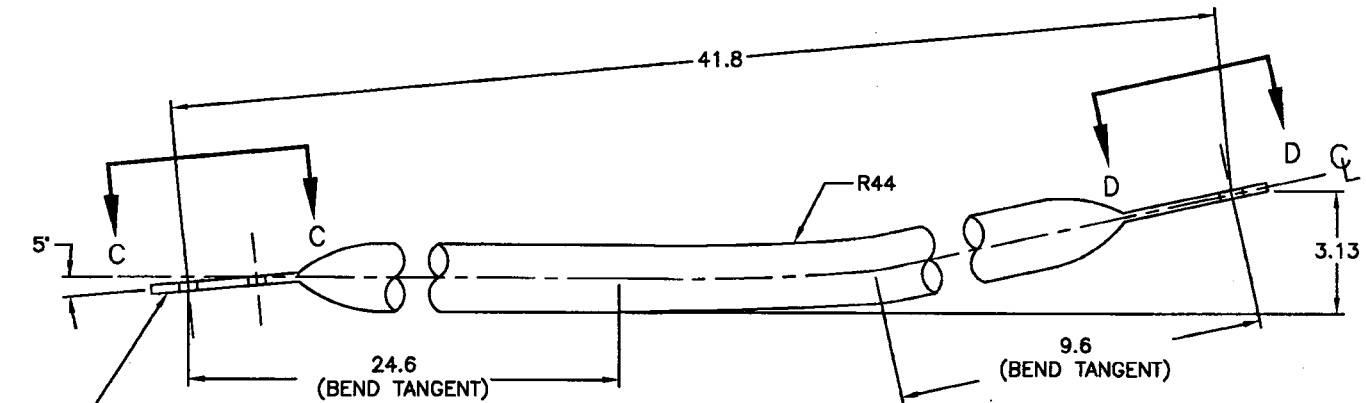


DETAIL A
SCALE 1:1

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
✓	✓	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
✓	✓	D3180	SHEET 2 OF 2
DATE		TITLE	SCALE
07.05.23		STRUT ASSEMBLY	1:2

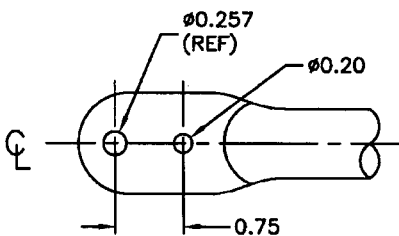


D3180-1 STRUT

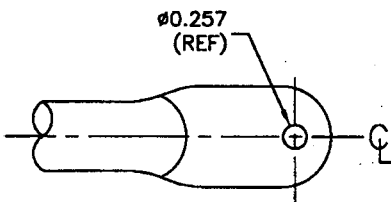
RELEASED
07.06.08

NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
Ø0.75 X 0.065 WALL
(REF. DART SPEC M304TRO.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERMANENT INK MARKER



VIEW C-C



VIEW D-D